

For Basket w/o 143886 SHIP MAI 13

Work Order ID 143891

143891

Page 1

Monday, March 28, 2016 10:13:56 AM

Item ID: D206-797-211

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 4/6/2016 Start Qty: 1.00

1

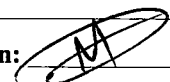
Cust Item ID:

Required Date: 4/18/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: 

Date: 16-3-28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-797-2	C

DAS

6

0.00 9-89

100

Document Control

DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD206-797-211 CHG002

DAS

27

9-89

APR 21 2016

MJ 16-04-07

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS

6

9-89

DAS

28

9-89

APR 07 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS

27

9-89

APR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 143891***143891***

Page 2

Monday, March 28, 2016 10:13:56 AM

Item ID: D206-797-211 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH
Start Date: 4/6/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/18/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130						DAS			
Packaging	Memo	0.00				27			
Packaging	Identify and pack for shipping as per PPP D206-797-211					9-89			
	Location: FG034					APR 21 2016			
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				MCS			
Quality Control						APR 21 2016			

MCS APR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 1

143891

D206-797-211

Required Date: 4/18/2016

Required Qty: 1.00

Comments: IPP Rev:A 11.02.10 as per IIN rev.A DD verf:JLM IPP Rev:B
11.04.18 MS24694-10 TO MS24694-S10 DD verf:JLM IPP Rev:C 11.04.19
added(1) D4293-1(was missing) DD verf:JLM IPP Rev:D 11.09.12 @ chg
002 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4713-1		Manufactured	No			110	Each	7.0000	1	1		DAS 6 9-89	DAS 28 9-89
D4713-1 Spacer													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST121			7						
				138743			7						
MS3367-5-0		Purchased	No			110	Each	95.0000	1	1		DAS 6 9-89	DAS 28 9-89
MS3367-5-0 Tie Wrap													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST272			95						
				123164			95						
D4271-011		Manufactured	No			110	Each	3.0000	1	1		DAS 6 9-89	DAS 28 9-89
D4271-011 Beam Assy, Fwd													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST452			3						
				122942			1						
				131781			2						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

Picklist Print

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Work Order ID: 143891

143891

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 4/6/2016

Required Date: 4/18/2016

Start Qty: 1.00

Required Qty: 1.00

D4271-013

Manufactured No

110

Each

4.0000

1

1

D4271-013

Beam Assy, Aft

DAS

6 DAS
9-89 28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST453

4

122880

2

131697

1

141297

1

D4292-1

Manufactured No

110

Each

8.0000

2

2

D4292-1

Fitting

DAS

6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

st533

8

119389

3

123358

5

D4293-1

Manufactured No

110

Each

18.0000

2

2

D4293-1

Fitting

DAS

6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

st533

18

113294

1

114227

2

116905

4

122955

8

87769

1

97520

2

APR 07 2016



Work Order update only

Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other						
Date :		Step #:			QTY Effective :			MRB (QS1042) Approval			
Description Work Order Deviation					Disposition					Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due			FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence								
			OTHER :								

Picklist Print

Monday, March 28, 2016 10:13:56 AM

Work Order ID: 143891

143891

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 4/6/2016

Required Date: 4/18/2016

Start Qty: 1.00

Required Qty: 1.00

D4314-1 Manufactured No

110 Each 38.0000 4 4

D4314-1

Shim

DAS

6

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST091

38

120515

18

123102

20

DAS

28

9-89

D4314-3 Manufactured No

110 Each 55.0000 4 4

D4314-3

Shim

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST091

8

116106

8

ST103a

47

113351

18

119651

9

123115

20

AN6-17A Purchased No

110 Each 24.0000 2 2

AN6-17A

Bolt

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST334

24

m128403

9

m130466

15

APR 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Monday, March 28, 2016 10:13:56 AM

Work Order ID: 143891

143891

Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 4/6/2016

Required Date: 4/18/2016

Start Qty: 1.00

Required Qty: 1.00

AN6-20A Purchased No

110 Each 39.0000 2 2

AN6-20A
BOLT

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location Loc Qty Loc Code

over005 30

M133932 30

ST334 9

M128936 9

NAS1149D0663J Purchased No

110 Each 900.0000 8 8

NAS1149D0663J
Washer

DAS

6

9-89

DAS

28

9-89

DAS
27
9-89

Location Loc Qty Loc Code

ST260 227

M131618 227

ST260a 500

M134360 500

ST263 122

M133134 89

M133769 12

M133812 21

ST269 51

M126334 51

MS21042L6 Purchased No

110 Each 191.0000 4 4

MS21042L6
Nut

DAS

28

6

9-89

APR 07 2016

DAS
27
9-89

Location Loc Qty Loc Code

OVER007 100

m134055 100

ST303 91

m133938 6

m134257 35

m134502 50

Monday, March 28, 2016 10:13:56 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 143891

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Parent Item: D206-797-211

D206-797-211

Parent Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 4/6/2016

Required Date: 4/18/2016

Start Qty: 1.00

Required Qty: 1.00

MS27151-19

Purchased

No

110

Each

79.0000

4

4

MS27151-19

NUT

DAS

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST275

79

m128994

9

m132285

20

m132399

50

MS24694-S10

Purchased

No

110

Each

148.0000

4

4

MS24694-S10

SCREW

DAS

9-89
DAS
28
9-89

Location

Loc Qty

Loc Code

ST284

148

117442

48

120986

100

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 143891

Monday, March 28, 2016 10:13:56 AM

143891

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Item ID: D206-797-211

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Quick Release Mounting 206L / L1 / L3 / L4 Fits LH or RH

Start Date: 4/6/2016

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/18/2016

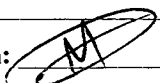
Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: 16-3-28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-797-2	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD206-797-211 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS APR 07 2016

DAS
APR 07 2016

Reference

5.0 PARTS LIST

Qty -021	Qty -022	Qty -023	Qty -024	Qty -211	Part Number	Description
X					D206-797-021	QUICK RELEASE HELI-UTILITY-BASKET
	X				D206-797-022	QUICK RELEASE HELI-UTILITY-BASKET
		X			D206-797-023	QUICK RELEASE HELI-UTILITY-BASKET
			X		D206-797-024	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D206-797-211	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4293-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP